

52

DART AEROSPACE LTD	Work Order:	22112
Description: Doubler	Part Number:	D3302-5
Dwg: D3302 Rev. A B16 12 04.11.25 PG	Qty:	10

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	JK	04.12.16	10
2	MV	Cut blank: 12.450" x 8.750" Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3302-5			
		Batch: M16455	CPL	05-01-17	10
3	MV	Machine as per Folio FA450 and Dwg D3302 Stack of 10 Identify as D3302-5	EP	05.01.18	10
4	QC2	Inspect parts as they come off the CNC machine	EP	05.01.18	10
5	QC8	Second check	EP	05.01.19	10
6	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	EP	05.01.19	10
7	GB	Form as per Dwg D3302	2	05.01.27	10
8	QC5	Inspect work to Step 7	12	05.01.31	10
9	FP	Chemical Conversion Coat as per QSI 005 4.1	MP	05.02.01	10
10	QC3	Inspect Chemical Conversion Coat	U	05.07.07	10
11	ST	Identify and Stock	U	05.02.02	10
12	AC	Cost / part <u>14.60</u>	54C	05.02.03	10
13	DC	Close W/O <u>14.60</u> Inspect Level 21	JK	05.02.04	10

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	

RELEASED
04.09.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22112
Description: Doubler		Part Number:	D3302-5
Inspection Dwg: D3302	Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article

Measured by:	EP	Audited by:	JL	Prototype Approval:	N/A
Date:	05/01/18	Date:	05.01.18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	<i>[Signature]</i>

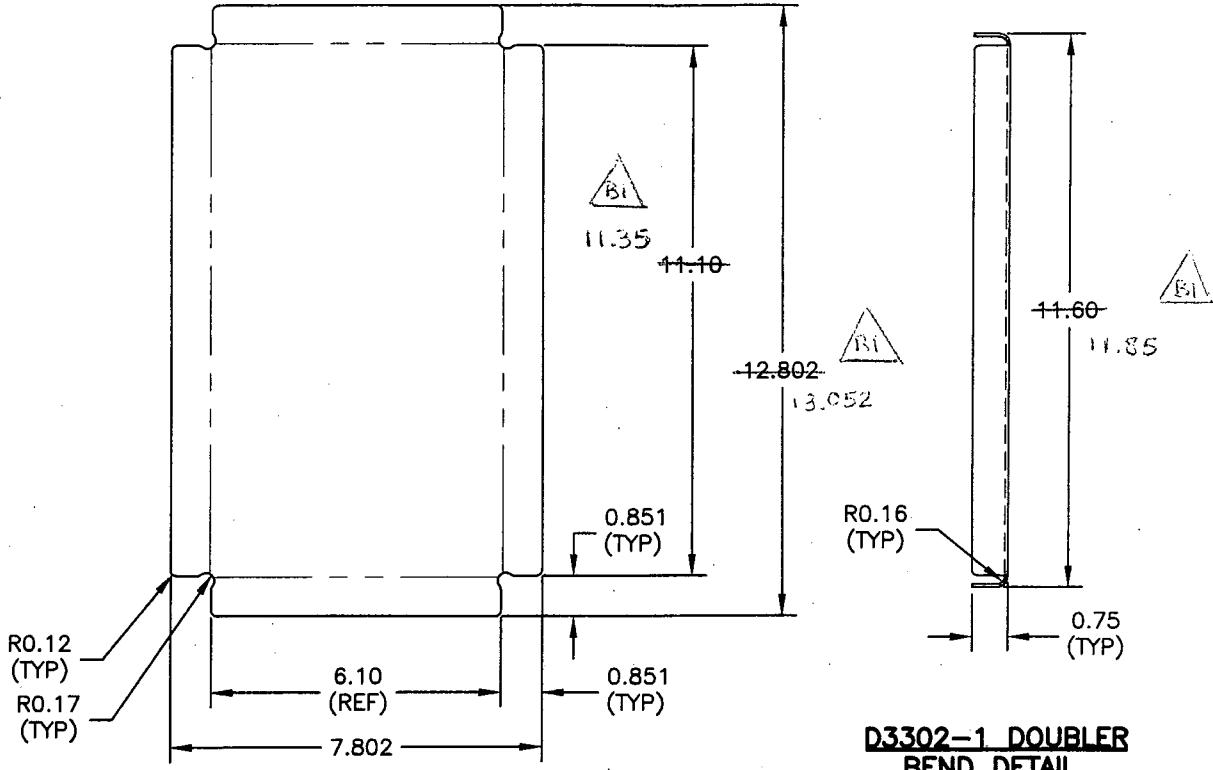
H:\FORMS\Quality Assurance\approved QA\FAI revD

REF ID: A651856
RELEASED
2010-09-07

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3302	REV. B SHEET 1 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4
A	04.07.06	NEW ISSUE	
B	04.11.18	REMOVE HOLES	
B1	RF 04.12.15	ADDED 0.25" TO THE LENGTH	

RELEASED
04.11.23 *[Signature]*

**D3302-1 FLAT PATTERN****D3302-1 DOUBLER
BEND DETAIL****SHOP COPY**RETURN TO
ENGINEERING**UNCONTROLLED COPY**SHEET 1 OF 4
REVISION B
CUT NOTICE**WORK ORDER****NO. 22112****D3302-1 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

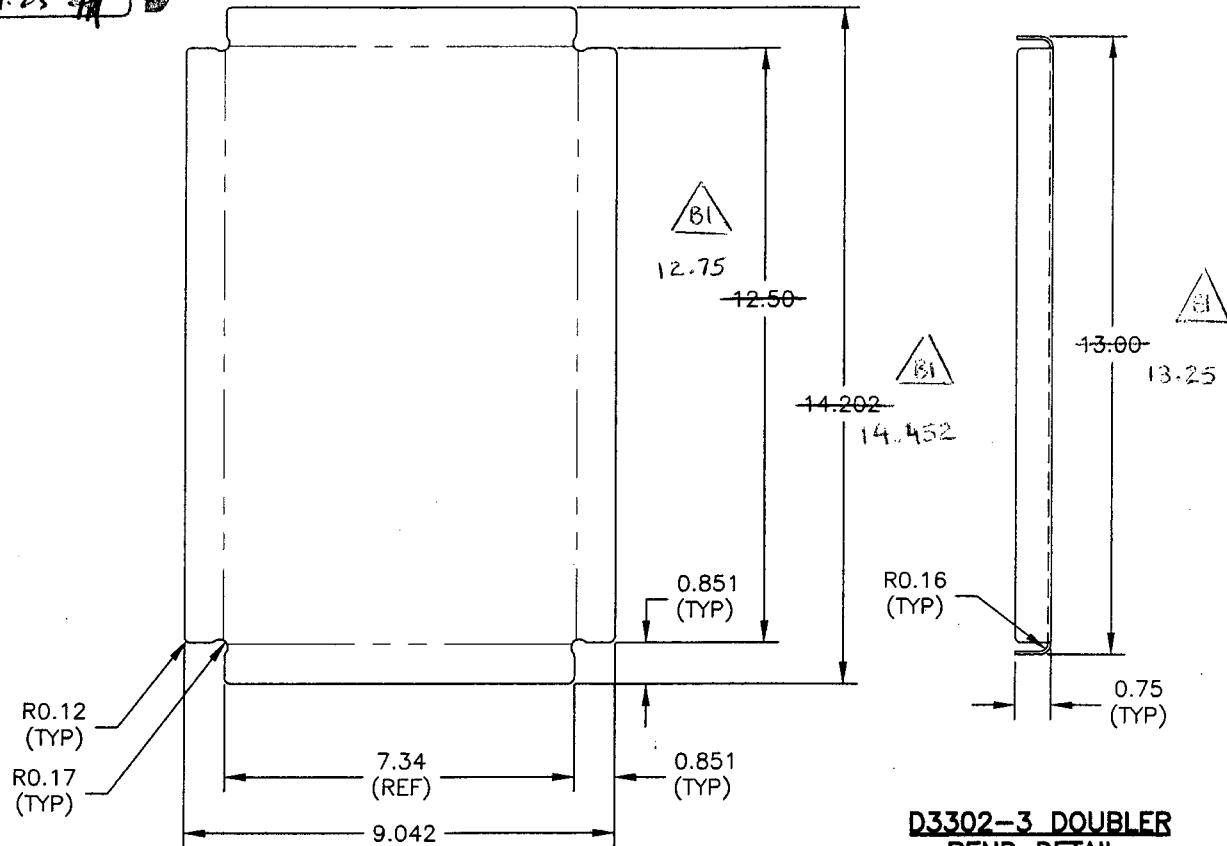
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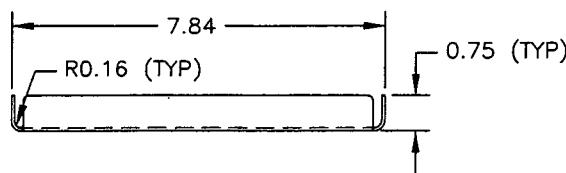


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3302	REV. B SHEET 2 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4

RELEASED
04.11.18 *[initials]*



D3302-3 FLAT PATTERN



D3302-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

SHOP COPY

RETURN TO
ENGINEERING

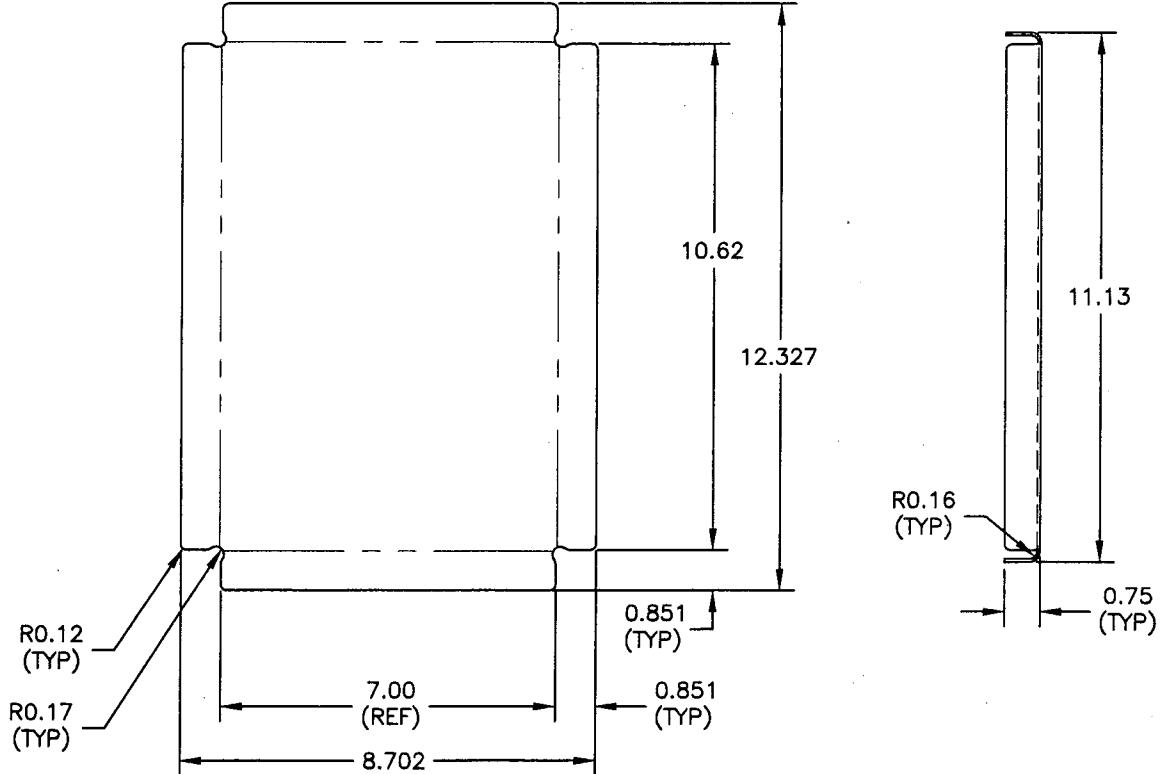
UNCONTROLLED COPY
SOME CHANGES MADE
CUT NOTICE

WORK ORDER

NO. 22112

DART

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3302	REV. B SHEET 3 OF 4
DATE 04.11.08		TITLE DOUBLER	SCALE 1:4

RELEASED
04.11.08 *[initials]***D3302-5 FLAT PATTERN****D3302-5 DOUBLER
BEND DETAIL
SHOP COPY**RETURN TO
ENGINEERINGUNCOPIED COPY
DOCUMENT
NOTICE

WORK ORDER

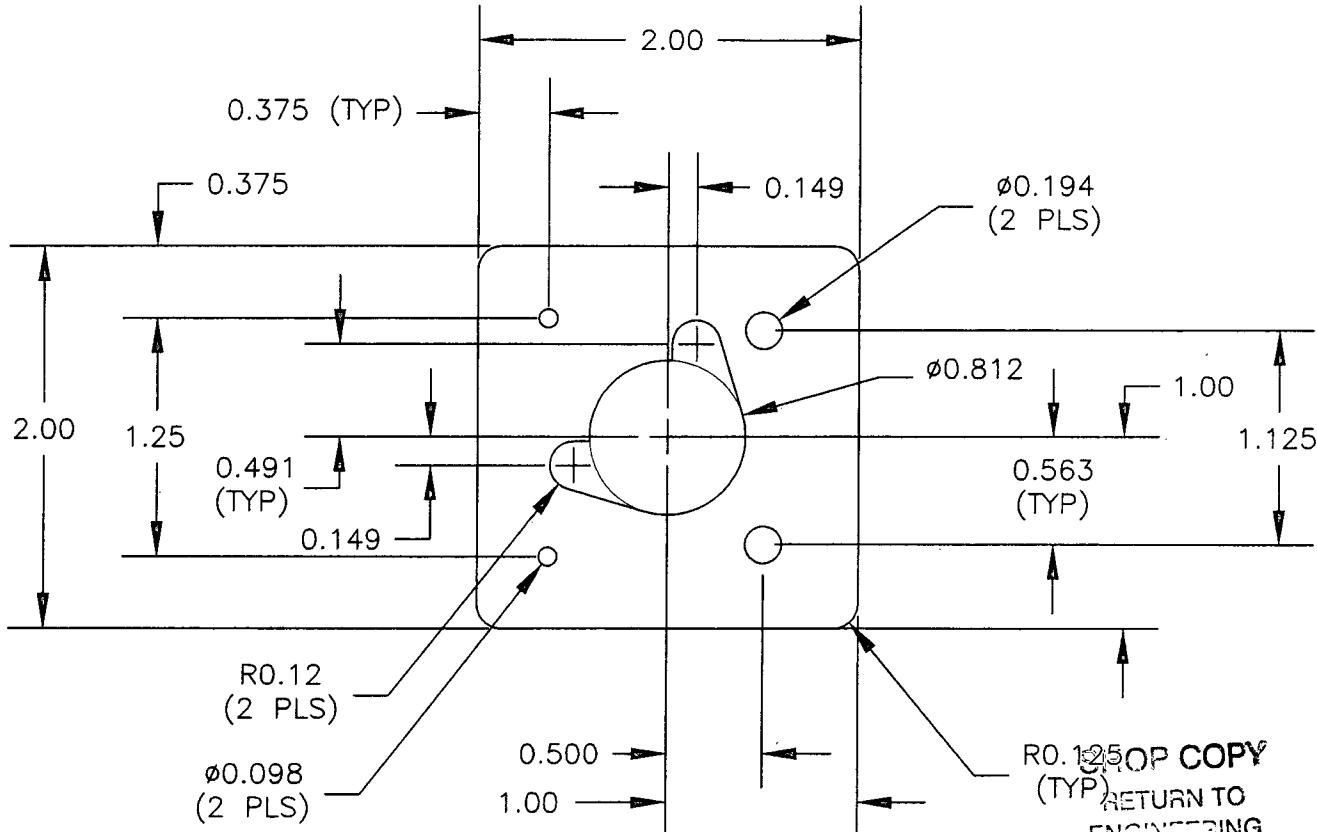
NO. 22112**D3302-5 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3302	REV. B SHEET 4 OF 4
DATE 04.11.18	TITLE DOUBLER		SCALE 1:1

RELEASED
04.11.23



D3302-7

UNCONTROLLED COPY
SUBJECT TO CHANGE
WITHOUT NOTICE

WORK ORDER
NO. 22112

D3302-7 NOTES:

- 1) MATERIAL: 5052-H32 OR 6061-T6 (QQ-A-250/8 OR QQ-A-250/11)
0.040 THICK (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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Job Costing Report

Dart Aerospace Ltd.
HawkesburyDec 16, 2004
12:38 pm

Work Order No : 0022112
 Project Name : D3302-5
 Project For : WK452
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3302-5
 Description : Doubler
 Manufactured : Yes
 Amount Req'd : 10
 Amount Done : 0
 Start Date : 12-16-04
 Est Finish Date : 12-21-04
 Act Finish Date :
 Drawings Rqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00	0.00	0.00
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00	0.00	0.00
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00	0.00	0.00
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00	0.00	0.00
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00	0.00	0.00
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00	0.00	0.00
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00	0.00	0.00
Total Cost	0.00	0.00	0.00	0.00	0.00
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00